

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006610**Date Inspected:** 07-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng and Liu Young**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA inspector performed MT of approximately 15% and VT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as East Tower Lift 1 angle, gusset plates and channel beam on 9m/13m diaphragm of skin E. The weld designations reviewed are as follows:

Outside near Bay 11

1. ESD1-SA78-112,113, ESD1-SA227A/H-58, 59, ESD1-SA227F/H-77-90
2. ESD1-SA110-119,120, ESD1-SA227A/H-60, 61, ESD1-SA227A/H-36-49
3. ESD1-SA227G/H-5-8, ESD1-SA216J/K-11-14 and ESD1-SA216K/K-7-10

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as Tower Base shear plate. The weld designations reviewed are as follows:

Bay 10

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

1. ED1-A27C/E-1A (B) and 2A (B)

Bay 11

FCAW welding of weld joint 8B located on PCMK ESTL3-4B/K.

Welder is identified as Mr. Wang Jintao (205678). ZPMC QC is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U2.

Bay 10

SMAW welding of weld joint 24 and 25 located on ND1-A468-38M-2.

Welder is identified as Mrs. Chen Qiqiong (056364). ZPMC QC is identified as Mr. Liu Young.

The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding of weld joint 23 and 5 located on ND1-A468-38M-2.

Welder is identified as Mrs. Ye Xulan (040581). ZPMC QC is identified as Mr. Liu Young.

The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding of weld joint 28A/B located on ND1-A468-28M-2.

Welder is identified as Mrs. Xue Xidi (040365). ZPMC QC is identified as Mr. Liu Young.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G (2F)-FCM-Repair-1.

FCAW welding of weld joint 156 located on NSD1-A166G/J.

Welder is identified as Mr. Wu Zhizhong (057180). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 157 located on NSD1-A166G/J.

Welder is identified as Mr. Dong Yuqin (053116). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

Bay 2

This QA Inspector observed ZPMC welders ZPMC approved welders Jiang Jinyong (066361) and Zhou Bing (067764) performing the repair work on 1AAW. Welding was not in compliance due to consumable not properly stored in heating container. QA Inspector issued an incident report on this date for the welding observed.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents. QA Inspector issued an incident report on this date for the welding observed.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
